

Date: Thursday, 05/03/2009 10:31:53 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 BASKET BASE (SHORT)
 Job Number : 46309A
 Estimate Number : 10209
 P.O. Number :
 This Issue : 05/03/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D3265041
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3265 REVC
 Previous Run : 44259A Project Number : N/A
 Material :
 Due Date : 13/03/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : JUL 09.03.05
 Comment : Est Rev:C Re-Format 05-11-03 JLM
 Est Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified
 by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D31661 Basket Hoop



D3826-041 x 2 46088



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Qty 3 D3166-1 Basket Hoop Batch: U

✓ 2.0 M304TS0750W065 304 SQ Tube .75x.75x.065W



Comment: Qty.: 19.2150 f(s)/Unit Total : 19.2150 f(s)

3/4" x 3/4" x 0.065" wall 304/316 SS tubing.

(M304TS0.750W.065)

Batch: M11 0969

SAP 09-03-18

①

3.0 D22323 Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2232-3

Hinge bracket

B46084-71 B46389-71

PD 09-03-19

4.0 D2325 Support Gusset (350 Basket)



D2235-1

46303



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2325

Support Gusset

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	1.0	D3166-1 REPLACED WITH D3826-041 X2 B46088					
	4.0	D2325 REPLACED WITH D2235-1 X1 B46303 SIDE MESH D3833-1 B46091	W				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23273

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2327-3

Bushing

B39560

PD 09-03-20

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B45684

PD 09-03-20

7.0

D34425

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3442-5

Shim

B33202

PD 09-03-19

8.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 26.0000 sf(s)/Unit Total : 26.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

26sf

M304EX0.75-16F Expanded Metal

M110992

SAD 09-03-18

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-CUT (3) D2235-1 FROM D3166-1

SAD 09-03-18 ①

2-Drill hole in D3265-3 as per Dwg D3265

SAD 09-03-18 ①

3-Remove all markings from material

SAD 09-03-18 ①

4-Weld as per Dwg D3265 using Welding Table and corner JigDeburr as required

PD 09-03-20 ①

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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Pl 09.03.23

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

8 09/03/23 @

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

m110939 Pressure wash mo/

09/03/24

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*13:25
400°
13:56*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

mo/ Fx.

09/03/24 (X1)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JS

09/03/27

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Small Medium Fab

Seal support gusset seam with White Sikaflex-291

Batch: *M109883*

Expiry date: *09/11*

JS 09.03.26 (X1)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/03/27 @

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O

46309.

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Do 4/03/07
MK 09-03-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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QTY -041	PART NUMBER	DESCRIPTION
X	D3265-041	BASKET ASSEMBLY
2	D2232-3	HINGE PLATE
4	D2235-1	RIB
4	D2325	SUPPORT GUSSET
2	D2327-3	BUSHING
2	D2581	MOUNTING BRACKET
2	D3265-1	RIB
2	D3265-3	RIB
2	D3265-5	RIB
2	D3442-5	SHIM

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 463014



NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

RELEASED

C	DRAWING UPDATED TO CURRENT STANDARDS. SHT 4 ADDED. RIB MATERIAL WAS 0.060 THICK. SHT 2 ZONE D5 25.63 DIMENSION WAS 27.63.	AJS	08.08.14
B	INCORPORATED A1. ADD SHIM UNDER HINGES. ADD HOLES FOR SPLIT LID BASKETS.	PH	05.06.08
A	NEW ISSUE	CP	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3265	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.08.14	COPYRIGHT © 2004 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

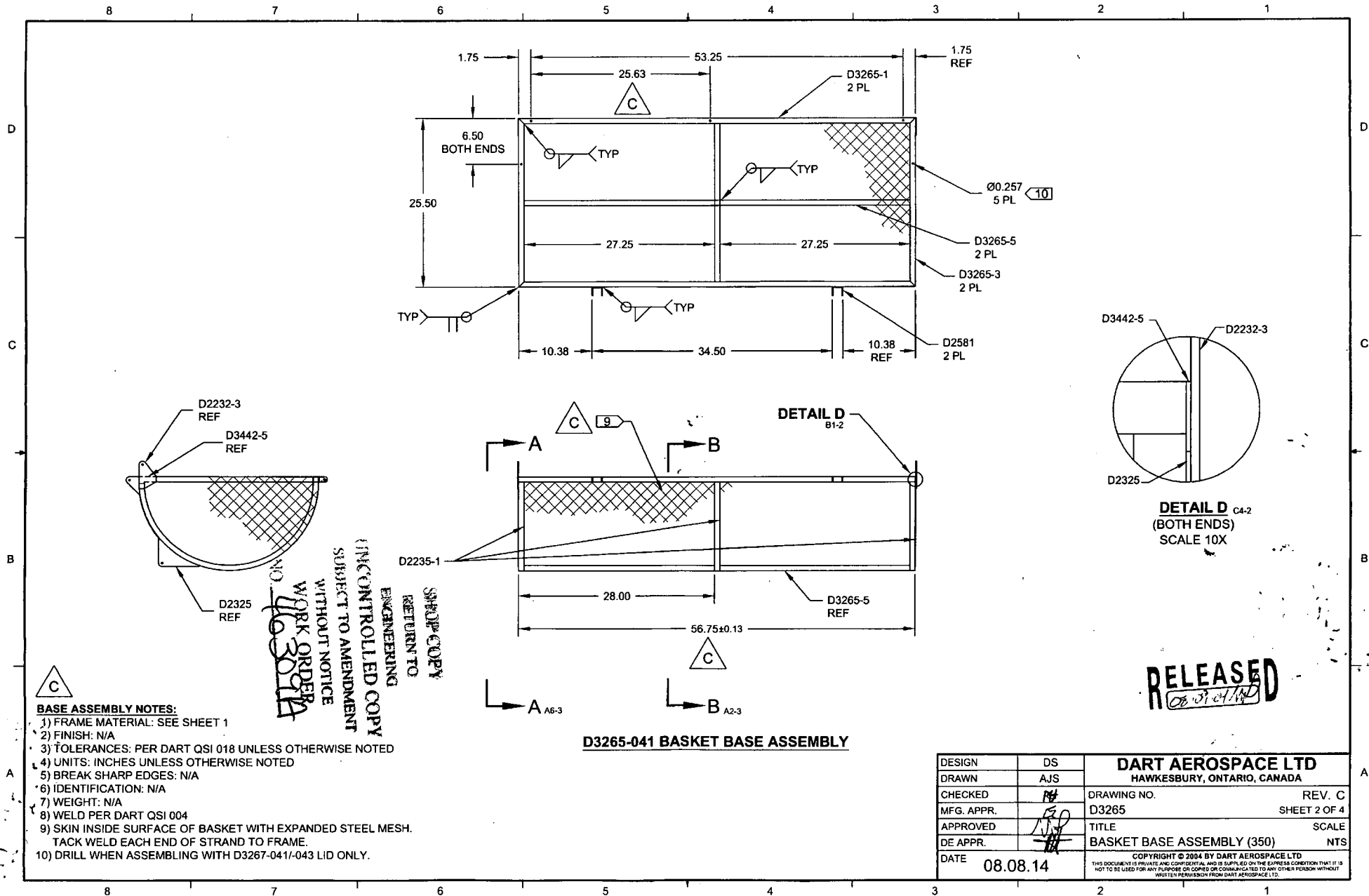
W/O:		WORK ORDER CHANGES					
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Dart Aerospace Ltd

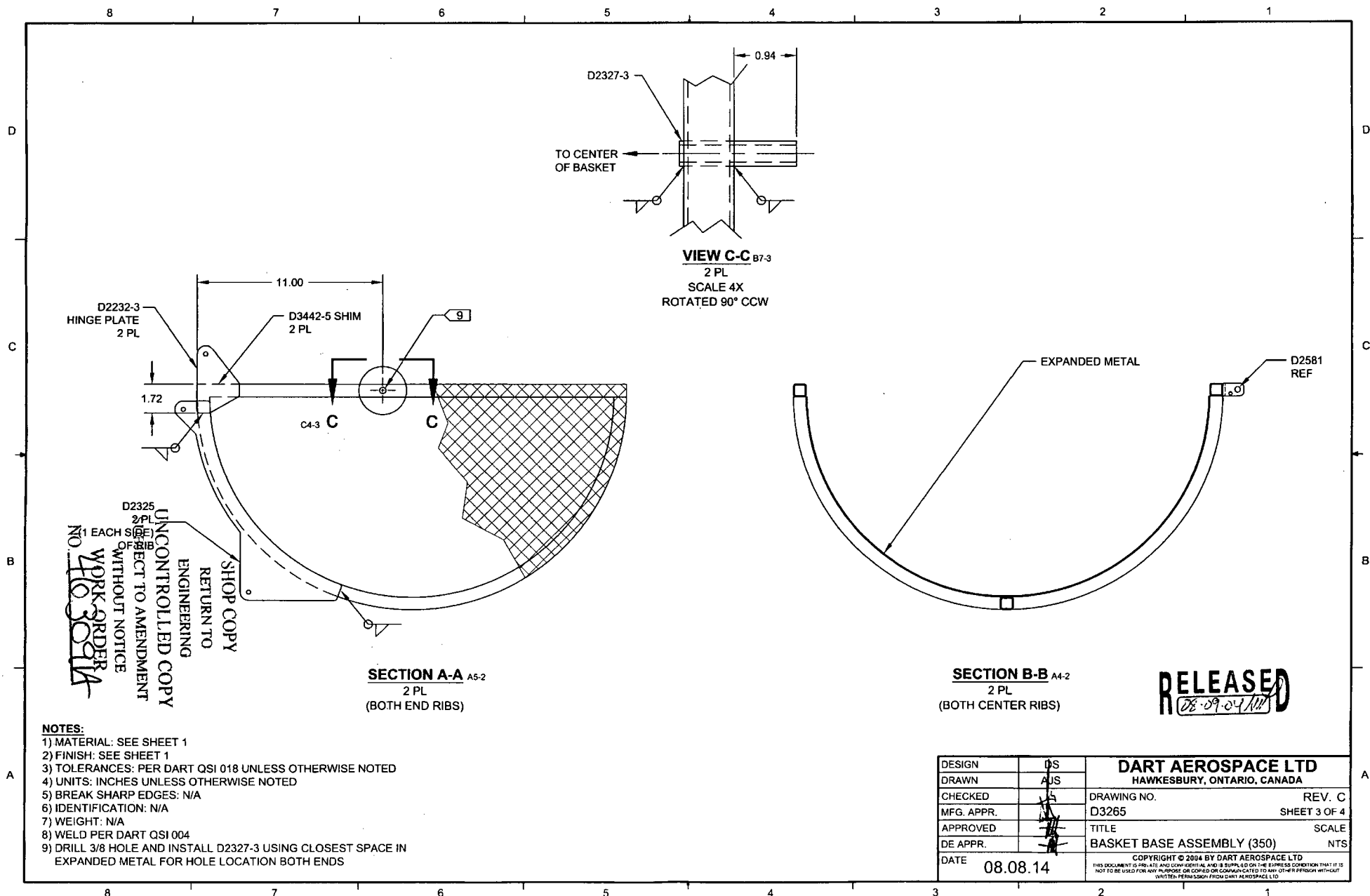
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NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DRILL 3/8 HOLE AND INSTALL D2327-3 USING CLOSEST SPACE IN EXPANDED METAL FOR HOLE LOCATION BOTH ENDS

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.	JS	D3265	SHEET 3 OF 4
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSEMBLY (350)	NTS
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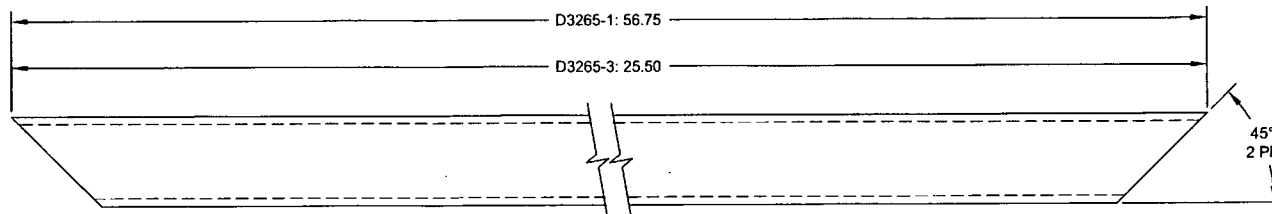
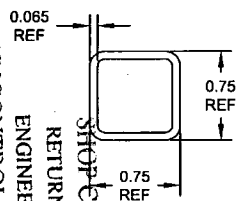
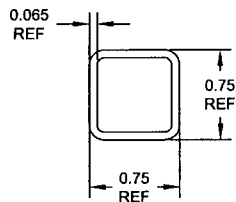
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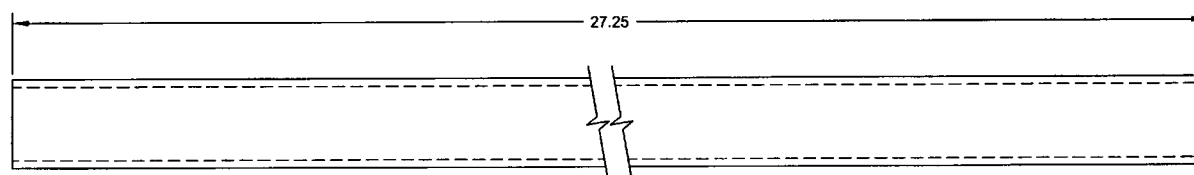
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D3265-1 RIB

D3265-3 RIB



D3265-5 RIB

RELEASED
08-07-04

- NOTES:**
- 1) FRAME MATERIAL: SEE SHEET 1
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

NO. 103011
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
STOP COPY

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RL	DRAWING NO.	REV. C
MFG. APPR.	CEP	D3265	SHEET 4 OF 4
APPROVED	1.1	TITLE	SCALE
DE APPR.	1.1	BASKET BASE ASSEMBLY (350)	NTS
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